

Date: Wednesday, 16/04/2008 3:53:32 PM  
 User: Julie Lecocq

## Process Sheet

|                                  |  |                         |                         |
|----------------------------------|--|-------------------------|-------------------------|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b>     | : 205 SKIDTUBE "I" BEAM |
| <b>Job Number</b>                | : 38642  |                         |                         |
| <b>Estimate Number</b>           | : 10346  |                         |                         |
| <b>P.O. Number</b>               | :  | <b>Part Number</b>      | : D2596                 |
| <b>This Issue</b>                | : 16/04/2008   | <b>S.O. No.</b>         | :                       |
| <b>Prsht Rev.</b>                | : NC   | <b>Drawing Number</b>   | : D2596 REV D           |
| <b>First Issue</b>               | : / /  | <b>Project Number</b>   | : N/A                   |
| <b>Previous Run</b>              | : 38394  | <b>Drawing Revision</b> | : D                     |
|                                  | <b>Type</b> : LANDING GEAR   | <b>Material</b>         | :                       |
| <b>Written By</b>                | :  | <b>Due Date</b>         | : 09/05/2008            |
| <b>Checked &amp; Approved By</b> | : <u>JLD 08-4-14</u>   | <b>Qty:</b>             | 4 Um: Each              |
| <b>Comment</b>                   | : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D<br>M<br>Est Rev:E 07-07-09 Incorporated DEO 9183 JLM |                         |                         |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |           |                       |
|-----|-----------|-----------------------|
| 1.0 | D25003100 | Ext'n -I" Beam Web 4" |
|-----|-----------|-----------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Extrusion "I" Beam Web 4"

Pick;

|     |             |             |        |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch  |
| 1   | D2500-3-100 | Extrusion   | B33940 |

JD 8-4-17

|     |             |                       |
|-----|-------------|-----------------------|
| 2.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|

**Comment:** LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

JD 8-4-17

|     |                 |                            |
|-----|-----------------|----------------------------|
| 3.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



**Comment:** HAND FINISHING RESOURCE #1  
 Acid Etch and Alodine per QSI 005 4.1

JD 8-4-17

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

DP

8-4-17

(4)

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 38642

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*Skidtube Cell*

*DP 8-4-17*

*(4)*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/04/21*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mf 08-04-18*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

**HAWKESBURY, ONTARIO, CANADA**

DRAWN BY

**APPROVED**

**DRAWING NO.**

REV. D

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OFFICE OF THE

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205 WEB

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96.09.16

NEW ISSUE

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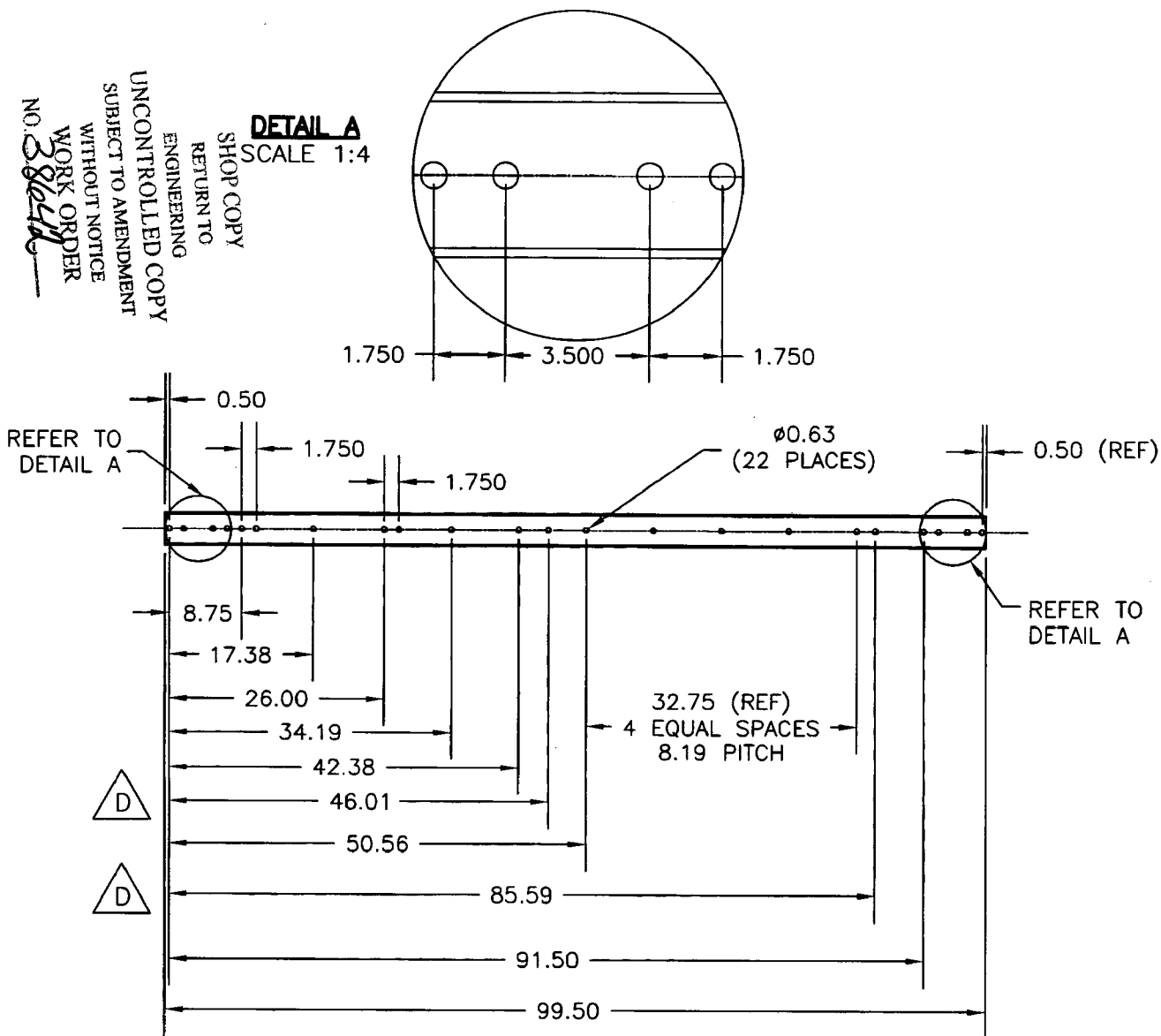
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30.09.14

INCORPORATED DEU 303 /

RECEIVED  
JUN 28 1968

07.06.28



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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